

Work Order ID 51539

August 25, 2009 1:35:57 PM

Page 1

Item ID: D2855

Accept

Setup Start

Revision ID: A

Stop

Item Name: Cap

Start Date: 8/28/09 Start Qty: 100.00

Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 100.00

Customer:

Reference:

Approvals:

Process Plan: *RD*

Date: *09-8-25* Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2855

Rev A

100

0.00

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: *10261* Cast per Dwg D2855 Material Release Note Required

CX 09/08/26 100

110

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

09/10/09 (100)

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

2> 809/10/19 ASP013

ccntb
(100) P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51539

August 25, 2009 1:35:57 PM



Page 2

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Accept



Setup Start



Revision ID: A

Stop



Item Name: Cap

Start Date: 8/28/09 Start Qty: 100.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- Drill as per Dwg D2855 using DT8235 12- Open holes to 19/64" 13- Deburr

⇒ M-k 09/10/20

100X

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ Sakai/21

QSP 015

Count 9
X100

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

2:15pm

FINISH TIME:

OVEN TEMPERATURE:

320°F

⇒ Jd 09/10/21

X100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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August 25, 2009 1:35:57 PM

Page 3

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Start Date: 8/28/09 Start Qty: 100.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

BR 09-10-21 (100)

QC

Memo

0.00

Quality Control

170

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

BR 09-10-22

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

2) 8/21/22

count
(100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51539

August 25, 2009 1:35:57 PM

Page 4

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Start Date: 8/28/09

Start Qty: 100.00

Required Date: 9/11/09

Req'd Qty: 100.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: *EPG*

0.00

BR 09-10-22 (100) /

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/23

MF 09-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:35:56 PM

Page 1

Work Order ID: 51539

Parent Item: D2855RevA

Parent Item Name: Cap

Comments:

Start Date: 8/28/09

Required Date: 9/11/09

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			100	Each	877.0000	200.0000			



INSERT



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

100895

100896

102018

110118

111529

111581

877

21

102

102

52

300

300

170

Each

0.0000

100.0000

D2855PRevA

Purchased

No



Cap



200

BR 09-10-22

CX 09/08/26 100

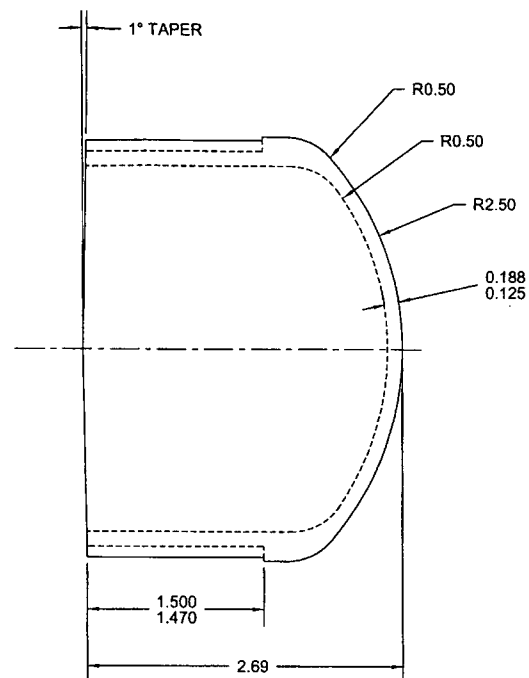
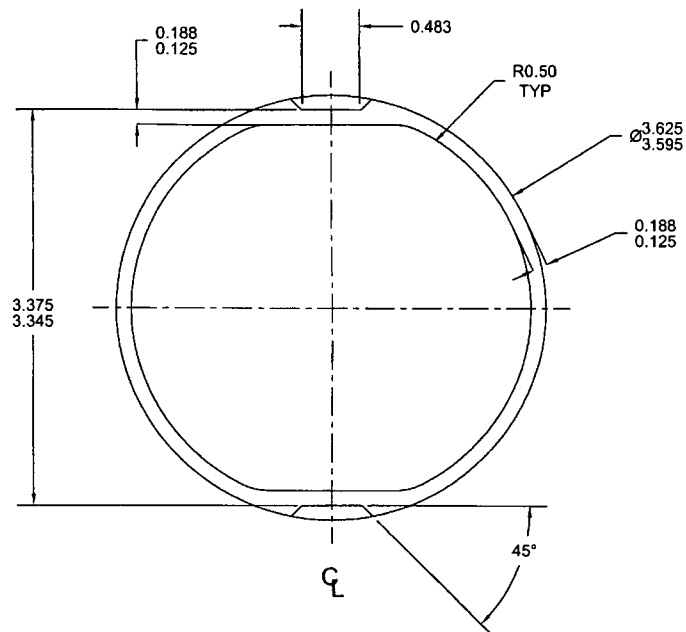
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



D2855C CASTING DETAIL



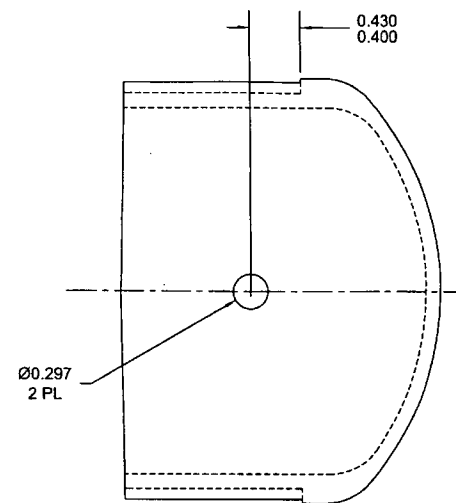
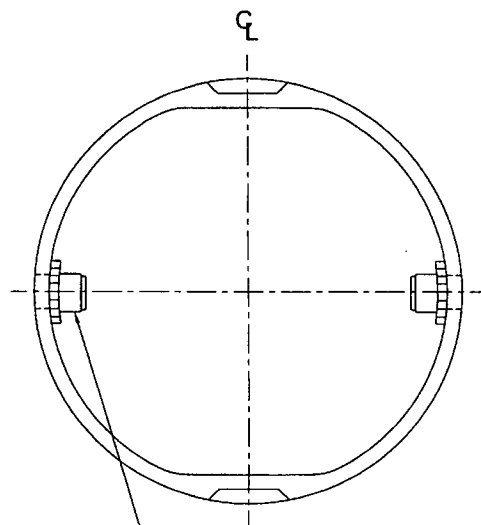
NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D2855	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
09/12/15 AND

51539



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP (MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

51539

RELEASED
21/07/15

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 2 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing
Date: **07/10/2009** Slip No. **33157, 33156**

Hawksbury, ON, K6A 1K7

Votre No. Commande **10467, 10261**
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats di détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
25pcs	D 2855 CAP	Z098046	A356.2	ingot#0853478
100pcs	D2855 CAP	Z098046	A356.2	ingot#0853478
<i>Sorkols</i>				

Analyse
Analysis (as in ingot)

(Si)	7.17%	(Al)	balance
(Fe)	0.087%		
(Cu)	0.0024%		
(Mn)	0.0017%		
(Mg)	0.37%		
(Zn)	<0.001%		
(Ti)	0.16%		

Donne
Yield :

Résistance a la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :
Par/Per :

Coc-100

Aluminum Foundry Ltd

St. Francois
H9P 1K3
683 9777
683 0375

info@foundryafpw.com

RECEIVED**OCT 15 2009****INVOICE**

Invoice No.: 33156
Date: Oct 07, 2009
Ship date: Oct 07, 2009
Order No. 10261

Sold to:

DART AEROSPACE
1270 ABERDEEN STREET
HAWKSBURY, ONTARIO K6A 1K7

Ship to:

DART AEROSPACE
1270 ABERDEEN STREET
HAWKSBURY, ONTARIO K6A 1K7

Tel. (613) 632-5200 Fax (613) 632-5246

Item No.	Unit	Quantity	Description	Unit Price	Amount
Z098046	Each	100	D2855 CAP REV.A 3 - GST @ 5%; GST S 09/10/09	16.90	1,690.00 84.50
Aluminum Foundry Ltd GST: #136149242 RT0001					
Shipped By: Fedex Tracking Number:				Total Amount	1,774.50
Terms: Net 30. Due Nov 06, 2009. Comment:					